

DART AEROSPACE LTD	Work Order:	24209
Description: Wearplate	Part Number:	D3319-1
B per PH 05.09.02 Dwg: D3319 Rev. A page 1	Qty:	4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	05/09/02	4
2	PG	Issue P/O: 2008582 Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3319 Possible Supplier: Industrial Laser Material release note is required	U	05-09-02	4
3	RG	Receive and inspect for transit damage Ensure material release note is attached	CD	05/09/20	4
4	QC6	Inspect dimensions as per inspection template D3319-1T1	CD	05/09/20	4
5	GA	Deburr if necessary	N	IR	W
6	GB	Form using DT8326 & DT8261 as per Dwg D3319 Dwg Rev: B	SB	05/09/20	4
7	GB	Form flat on press using DT8776 block Dwg Rev: B	SP	05/09/22	4
8	QC6	Inspect dimensions as per Dwg D3319	CD	05-09-22	4
9	WS	Trace weld location using D3319-1T3 and Dwg D3319 Weld hard surface using D3319-1T2 as per QSI 004 and Dwg D3319 Dwg Rev: B	CPL	05.09.26	2
		Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod M17914	CPL	05.09.26	2
10	QC9	Inspect weld	M	05/09/26	2
11	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	ML	05/08/27	1
12	QC3	Inspect Powder Coat	CD	05/09/27	2
13	ST	Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA04-18 PDA05-18 and Stock	SB	05/09/27	2
14	AC	Cost / part: 90.56	CD	05/09/27	2
15	DC	Close W/O Inspect Level 21	(S)	05/09/28	2

Rev	Date	Change	Revised By	Approved
A	05.05.12	New issue	KJ/JLM	CD

PRELIMINARY ISSUE

Procedure change

by date app. QC app. Dsg. eng.

Step 8b	<i>JK</i> 050926	add step 8b to ^{layout} weld location with new jig D3319-IT3	<i>JL</i>	05, gr. ^{to}	<i>JK</i> 050927	<i>JK</i> 051012
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8b U Remove 1 for weld jig

050926 U

SHOP COPY

RETURN TO

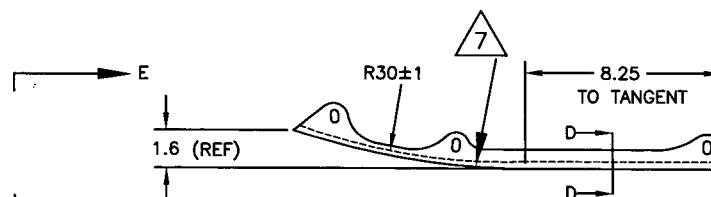
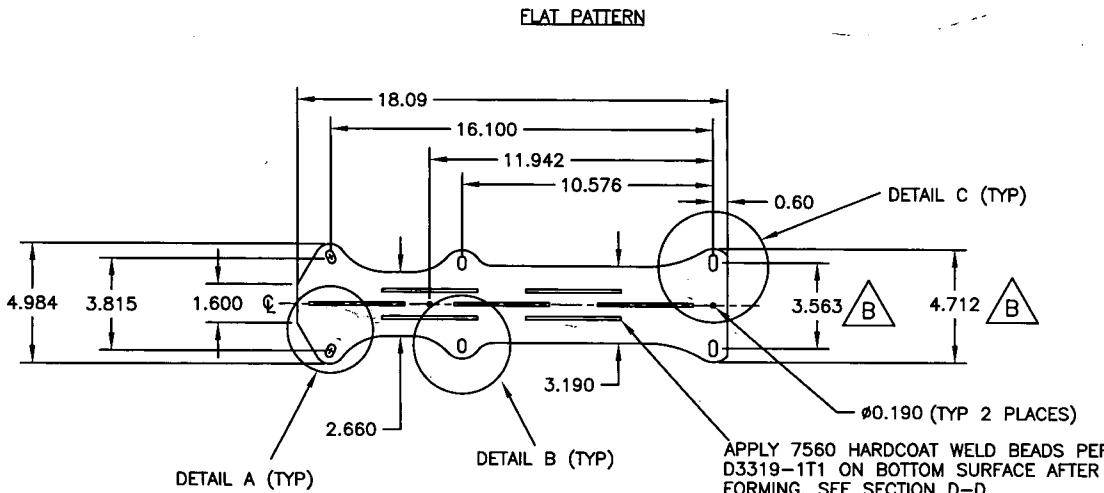
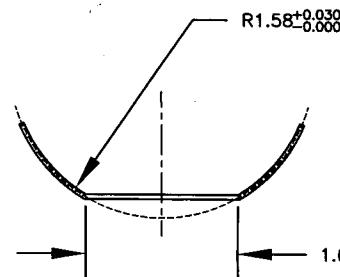
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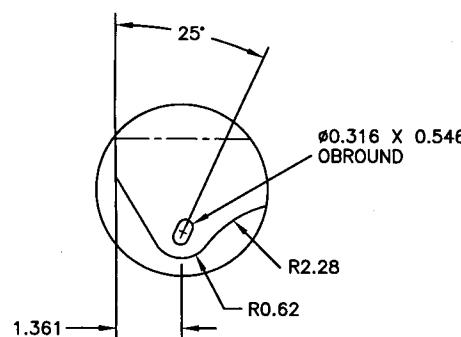
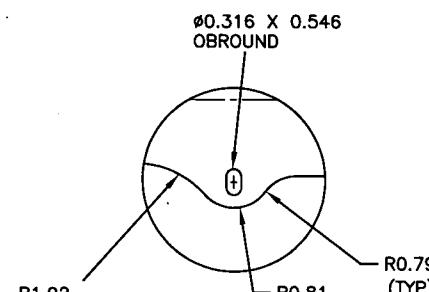
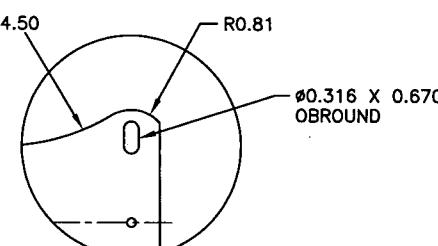
WORK ORDER

NO. 24701

SECTION E-E (SCALE 1:2)



BENDING DETAIL

DETAIL A
(SCALE 1:4)DETAIL B
(SCALE 1:4)DETAIL C
(SCALE 1:4)D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN		DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA	
DATE		TITLE	SHEET 1 OF 5	
A 05.06.06		04.09.24 NEW ISSUE	D3319	
B 05.06.06		05.06.06 WEARPLATE		1:8

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 02, 2005
01:45 pm

Work Order No : 0024209
 Project Name : D3319-1
 Project For : WK537
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3319-1
 Description : Wearplate
 Manufactured : Yes
 Amount Req'd : 4
 Amount Done : 0
 Start Date : 09-02-05
 Est Finish Date : 09-12-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 6989 / 376 6111 Auckland
(09) 235 8089 / 235 3535 Waiuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5005/21329

CUSTOMER	Wilkinson	P41007DI002	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC107797																						
CUSTOMER OIN	90-21N-288		PRODUCT	CRA WIDE COIL	PAGE	1 of 1																						
MILL OIN	453666		DIMENSIONS	0.044" x 48" x Coil	DATE	31 March 2005																						
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT										MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)																
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	x10000	x100	180°	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH (feet)	
		x100										x1000																
R9-455948-00	639184	6	1	20	12	16	12	18	26	4	7	1	1	1							Good				49		1729	
R9-455949-00	639184	6	1	20	12	16	12	18	26	4	7	1	1	1							Good				49		1296	
R9-455951-00	638495	5	1	20	13	19	12	19	17	1	5	1	1	1							Good				49		2064	
R9-456216-00	638526	6	TR	20	12	18	12	18	18	4	6	1	1	1							Good				54		1926	
R9-456217-00	638526	6	TR	20	12	18	12	18	18	4	6	1	1	1							Good				54		1978	
R9-456218-00	636939	5	TR	20	12	20	13	17	25	TR	8	1	1	1							Good				52		1926	
R9-456219-00	636939	5	TR	20	12	20	13	17	25	TR	8	1	1	1							Good				52		1978	

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm	PLASTIC STRAIN RATIO (r) (A)=0 (B)=r90	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+S/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
OC METALLURGIST

18 ya CRMS

Peter Hum

From: David Shepherd [davids@dartaero.com]
Sent: Tuesday, September 27, 2005 10:50 AM
To: Peter Hum
Subject: Re: D3319-1/-3 changes

Peter,

It is acceptable to ship these parts. I will sign off the updated drawings when I am in Hawkesbury later this week.
Please ensure W/O refers to Rev. B of the drawings.

David

----- Original Message -----

From: "Peter Hum" <phum@dartaero.com>
To: "David Shepherd (E-mail)" <davids@dartaero.com>
Sent: Tuesday, September 27, 2005 8:39 AM
Subject: D3319-1/-3 changes

> David,
>
> The D3319-1/-3 wearplates for use on the D350-727-015 kit have been
modified
> to Rev. B. Rev. B has not been released. A fit and function has been
> performed and photographed to show that the D3319-1/-3 Rev. B wearplates
fit
> an OEM 350 skidtube. Is it suitable to ship the D3319-1/-3 wearplates at
> Rev. B?
>
>
> Peter
>
>